

Work Order ID 71155

Thursday, June 23, 2011 12:37:53 PM



Page 1

Item ID: D4151-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Eyebolt Receiver (Upper)

Start Date: 6/23/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 7/11/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: MF Date: 11-06-23

Tooling: _____ Date: _____

QC: _____ Date: _____

SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4151	C								

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blank to 2.960" long

crh 11/07/07

6

110

0.00



HAAS I

Memo

0.00

HAAS CNC vertical machine #1

1-MILL as per folio FA952 & dwg,
FOLIO REV: AA
DWG REV: C

2-Deburr as required

SL 11-07-26

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Customer:

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 11-07-26

6



QC

Memo

0.00

Quality Control

130

QC8- Inspect parts - second check

0.00

R 11-7-26

6

φ



QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: 134

0.00



Packaging

Memo

0.00

Packaging

- 11/7/26 JLB

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Required Date: 7/11/2011 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/7/26 JH
11-07-26
C

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 71155



Parent Item: D4151-7

Parent Item Name: Fwd Eyebolt Receiver (Upper)

Start Date: 6/23/2011

Required Date: 7/11/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 10-07-22 JLM VERIFIED BY:DD IPP
Rev:B 11.01.21 as per dwg revC DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M303B2.000X1.750		Purchased	No			100	f	6.7670	0.26	1.642105			

303 BAR 2" X 1.750"

Location

Loc Qty

Loc Code

MAT050

6.767

115047

6.767

1.643 and 11/07/07

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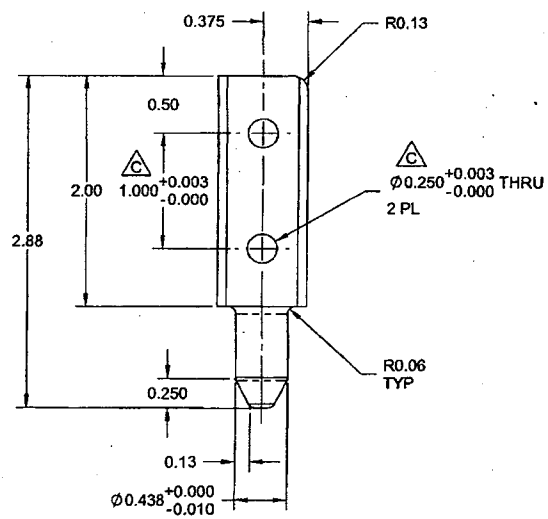
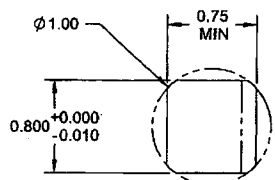
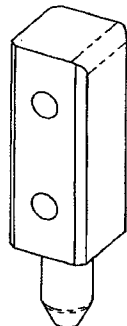
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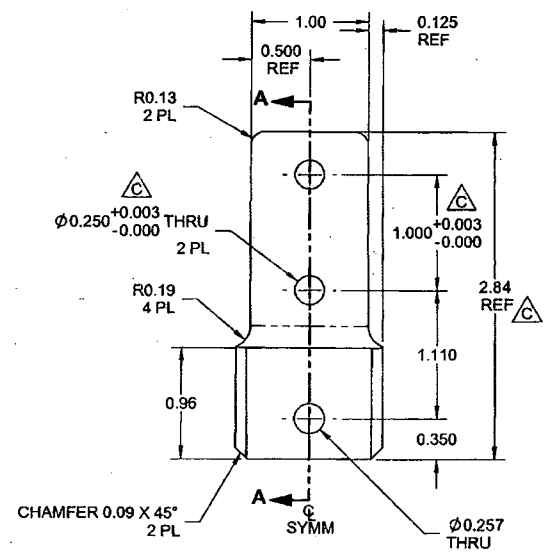
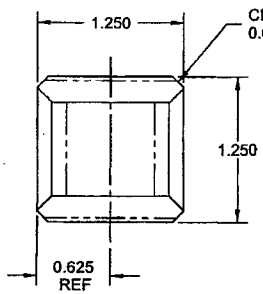
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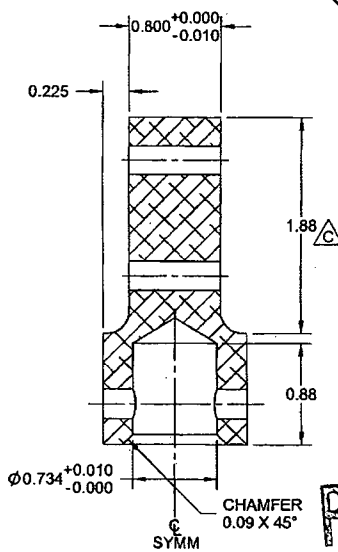
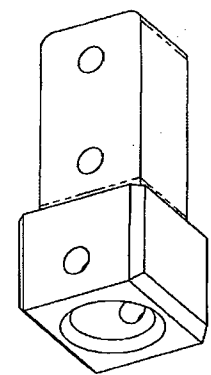
NOTE: Date & initial all entries



D4151-5 FWD BASKET INSTL STUD (LOWER)



D4151-7 FWD EYEBOLT RECEIVER (UPPER)



SECTION A-A

- NOTES:**
- 1) MATERIAL -5: 303/304/316 STAINLESS STEEL ROUND BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303R OR M304R
 - 7: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582
PER DART SPEC M303B OR M304B
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY AT ASSEMBLY
 - 7) WEIGHT -5: 0.36 lbs
-7: 0.70 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4151	REV. C
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE BASKET FWD HARDPOINT	SCALE NTS
DE APPR.			
DATE	10.12.14		

RELEASED
R 2011-01-10
RELEASED

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